

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000665**Date Inspected:** 21-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

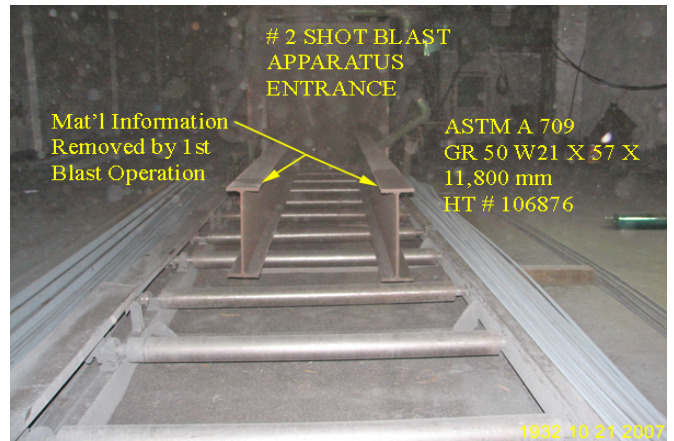
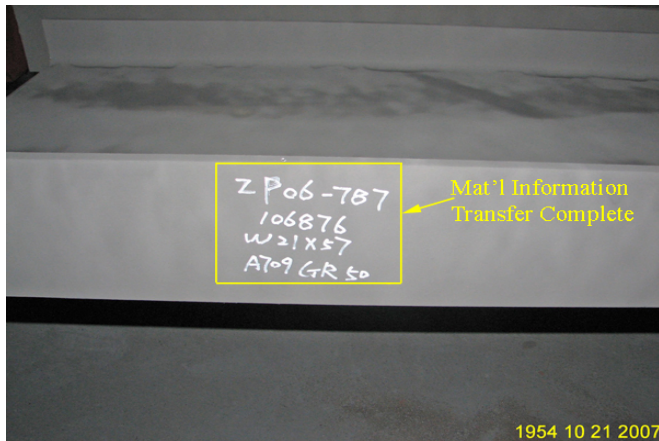
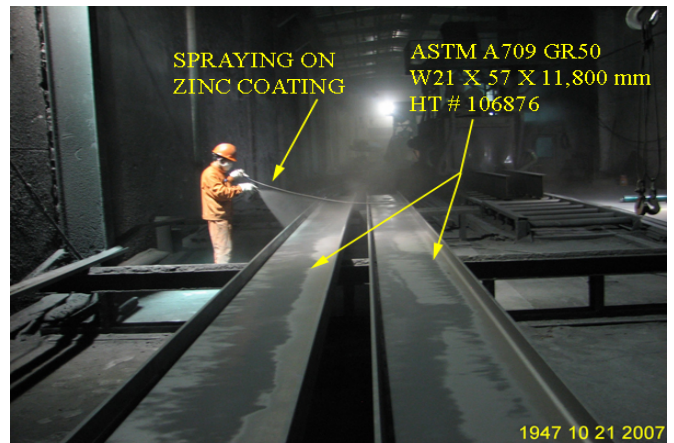
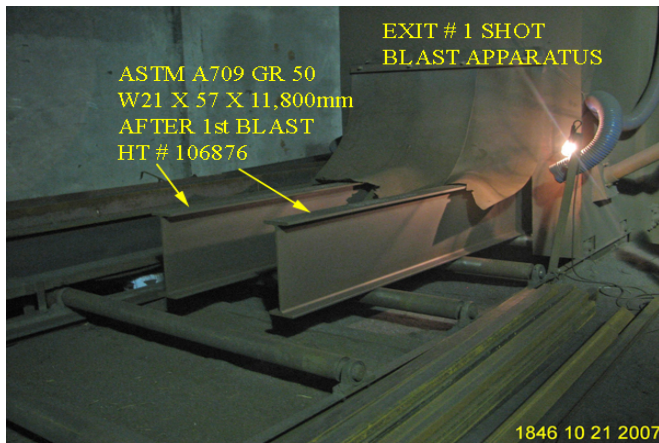
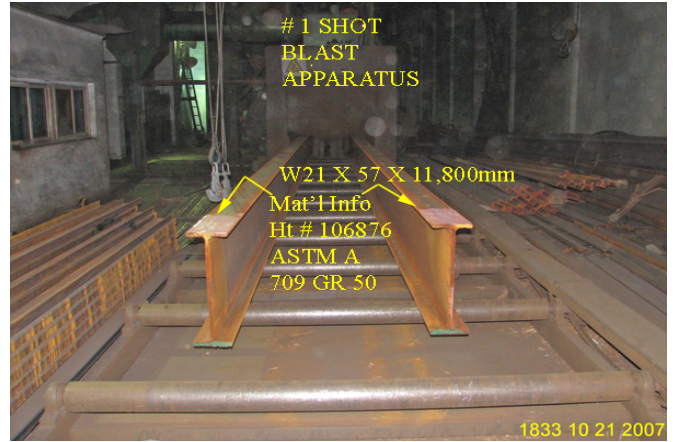
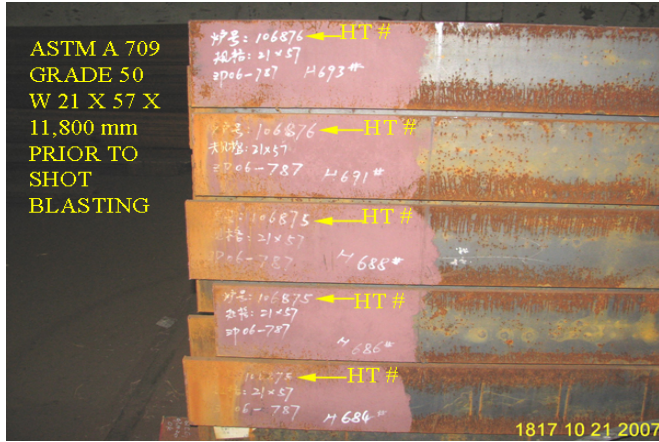
Bridge No: 34-0006**Component:** OBG - Shapes**Summary of Items Observed:**

OBG-Structural Shapes

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested by ZPMC QA Representative Eric Hu, to randomly verify sand blasting and coating operations of ASTM A709 GR50 W21 X 57 X 11,800 Structural Shapes (Beams). The QA Inspector randomly observed 18 each of the W21 X 57 X 11,800 Beams being shot blasted with 1.5 millimeter diameter steel shot and coated with a zinc protective coating. The QA Inspector observed the 18 Beams being run through 2 consecutive in line shot blasting apparatus, placed on horses and then spray coated. The QA Inspector randomly observed material information being recorded by ZPMC Quality Control personnel after placement on the shot blasting apparatus rollers, but prior to the actual shot blasting. The QA Inspector randomly observed the material information being transferred to the beams after the spray coating had been applied. The attached photographs provide additional detail.

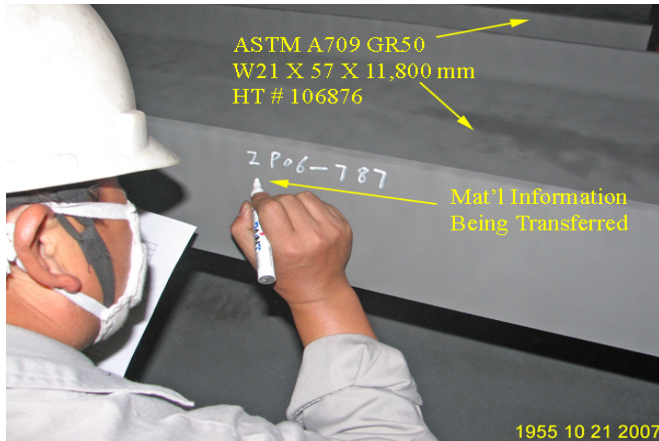
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Summary of Conversations:

The QA Inspector asked Mr. Hu copies of the Material Test Reports for the W21 X 57 X 11,800 Beams and Material Data Sheets for the zinc coating. Mr. Hu informed the QA Inspector that he would supply the QA Inspector with the requested information tomorrow.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Franco,Charlie	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
